

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012386**Date Inspected:** 03-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Mike Johnson, Jesse Cayabayab, JCWI, Presham			<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	SAS OBG 1E/2E-D	

**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process joint restoration and welding of the 1E/2E-A, The following observations were made:

**1E/2E-A**

Upon the arrival of the QA Inspector at the above identified location it was observed no welding or work was being performed. The QA Inspector noted due to adverse weather conditions and rain, the ABF personnel was working on the controlled welding environment. The QA Inspector randomly observed the ABF welding operators setting up the submerged arc welding (SAW) equipment in preparation of welding the above identified weld joint. The QA Inspector noted both of the SAW machines were in the welding connex but not set up by the end of the QA Inspectors shift. The QA ABF Assistant Welding Superintendent Dan Ieraci informed the QA Inspector ABF would like to commence welding on this date. Mr. Ieraci went on to inform the QA Inspector due to ABF not having to maintain the minimum required preheat for the full duration of the welding, ABF would like to weld a pass or two in the joint prior to the Day shift tomorrow. The QA Inspector noted no welding was performed on today's date. The QA Inspector noted the OBG 1W was picked and set on the trestle on today's date (pictured below).

**WQCP Review**

The QA Inspector sent the remainder of the shift performing WQCP review and organization of the submittal 1106 revisions 1-13. The QA Inspector was updating and performing organizational duties in of the original submittal and all approved revisions up to today's date of 3/2/10. The QA Inspector continued creating the QA reference

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# WELDING INSPECTION REPORT

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guide for QA duties, weld tracking and traceability, extent and frequency of non destructive testing and all approved welding procedures submitted by ABF.



## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bettencourt,Rick
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell,Bill
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QA Reviewer
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